INSTRUCTION & SAFETY MANUAL

MODEL ULTRASTAR 40

CALIBER .40 S&W

READ CAREFULLY BEFORE USING
YOUR FIREARM

STAR EIBAR ESPAÑA
cal. .40 S&W

10 COMMANDMENTS OF FIREARMS SAFETY

1 **ALWAYS** treat every gun as if it were loaded.

2 **ALWAYS** be sure the barrel is clear of any obstruction.

3 **ALWAYS** be sure of your backstop, what lies beyond and the safety of bystanders before you shoot.

4 **ALWAYS** use clean, dry, original factory-made ammunition of the proper type and caliber for your gun.

5 **ALWAYS** wear shooting glasses and ear protection when shooting.

6 **ALWAYS** carry your gun so that you can control the direction of the muzzle if you fall or stumble.

7 **ALWAYS** leave the safety on until you intend to fire.

8 **NEVER** leave an unattended gun loaded. Guns and ammunition should be stored separately, locked if possible, beyond the reach of children and careless adults.

9 **NEVER** allow your firearm to be used by anyone who has not read this Instruction and Safety Manual.

10 **NEVER, NEVER... EVER...**point any gun, loaded or unloaded, at anything you do not intend to shoot.

TECHNICAL DESCRIPTION

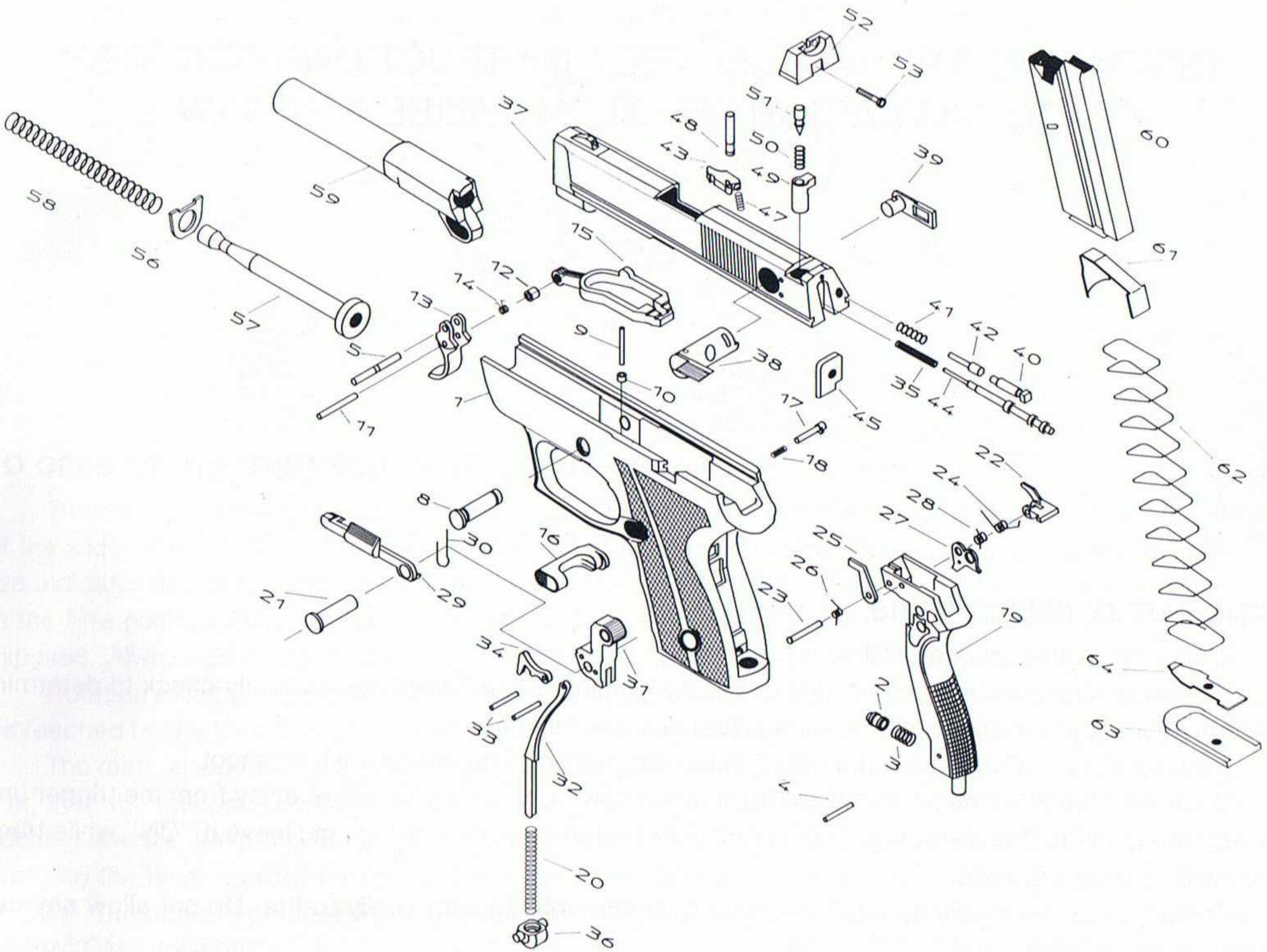
CONSTRUCTION	Polymer Frame
OPERATING	
Operating principle	Semi-automatic with short recoil of barrel.
Firing mechanism	Self-cocking with selective Double Action
Caliber	.40 S&W

DIMENSIONS AND WEIGHT

Overall length	176 mm.	= 6.93 in
Height	126 mm.	= 4.96 in
Width	29.5 mm.	= 1.16 in
Barrel length	89 mm.	= 3.50 in
Sighting line	134 mm.	= 5.27 in
Front sight width	3.25 mm.	= .128 in
Rear sight notch width	3.5 mm.	= .138 in
Weight of pistol with empty magazine	737 grs.	= 26 oz
Magazine capacity	8 rounds	

ULTRASTAR PARTS LIST

1 Frame
2 Backstrap retaining plunger
3 Backstrap retaining plunger spring
4 Backstrap retaining plunger pin
5 Trigger pin
8 Barrel pin
9 Barrel pin spring
10 Barrel pin spring bushing
11 Trigger bar pin
12 Trigger bar bushing
13 Trigger body
14 Trigger spring
15 Trigger bar
16 Magazine catch body
17 Magazine catch lock
18 Magazine catch spring
19 Backstrap
20 Hammer spring
21 Hammer pin
22 Sear
23 Sear and ejector pin
24 Sear spring
25 Ejector
26 Ejector spring
27 Sear pusher
28 Sear pusher spring
29 Slide stop lever
30 Slide stop spring
31 Hammer body
32 Hammer bar
33 Hammer bar and lock pins
34 Hammer lock
35 Firing pin spring
36 Hammer Spring Support
37 Slide
38 Firing pin safety roller
39 Thumb safety wing, right
40 Thum safety retaining plunger
41 Thumb safety spring
42 Thumb safety positioning plunger
43 Extractor
44 Firing pin
45 Firing pin retainer
47 Extractor spring
48 Extractor pin
49 Firing pin safety
50 Firing pin safety spring
51 Firing pin safety spring pin
52 Rear sight body
53 Rear sight screw
56 Recoil Buffer
57 Recoil spring guide
58 Recoil spring
59 Barrel
60 Magazine tube
61 Magazine follower
62 Magazine follower spring
63 Magazine floor plate
64 Magazine floor plate catch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OPERATING AND DISASSEMBLY INSTRUCTIONS FOR STAR MOD. ULTRASTAR PISTOL IN CALIBER .40 S&W

BASIC SAFETY PRECAUTIONS

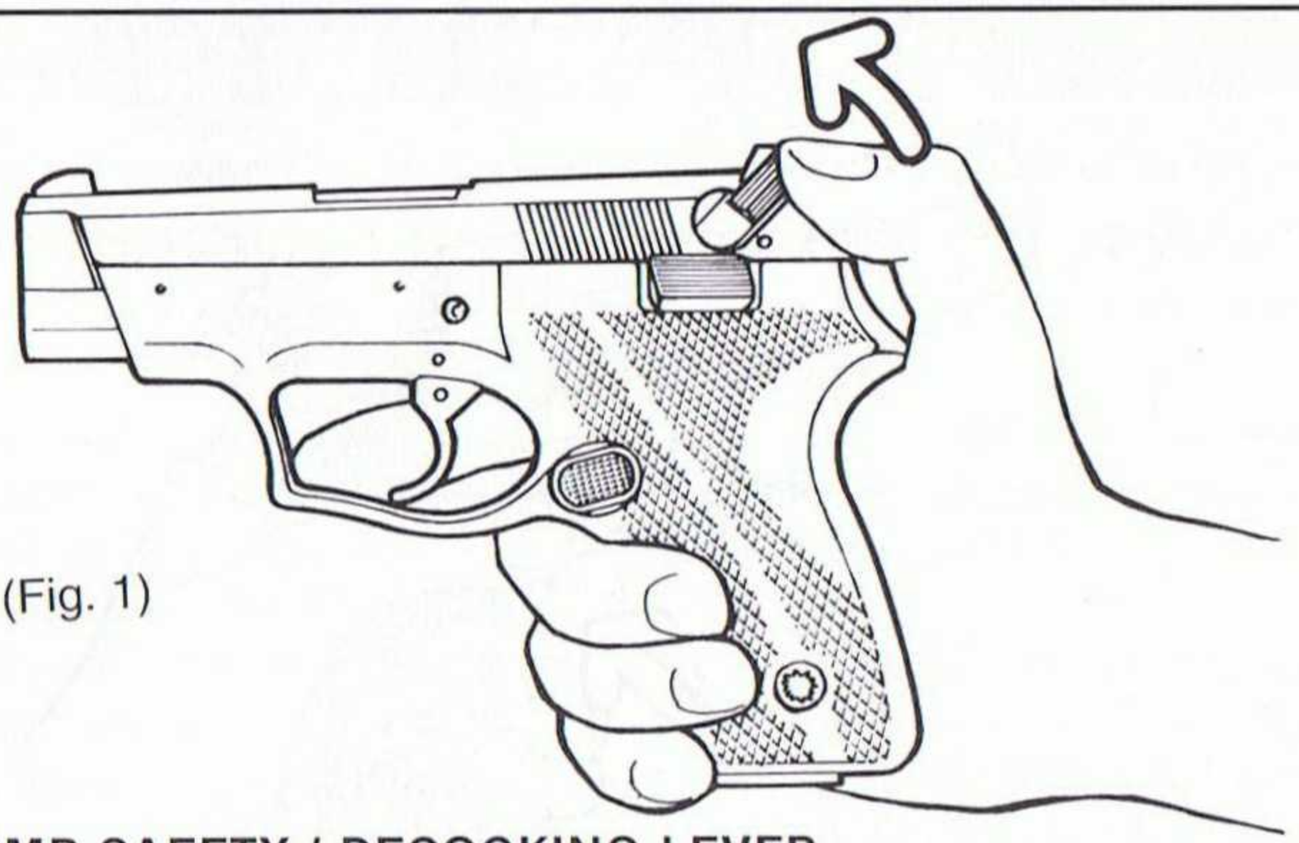
Always treat the pistol as if it were loaded.

Whenever first picking up the pistol, or before handing it to anyone else, carefully check to determine whether it is loaded. Inspect both the magazine and the chamber.

Never point the pistol -even if it is unloaded- at anything you do not wish to shoot.

Whenever handling the pistol, always keep the safety "ON" and your finger away from the trigger until you are ready to fire. Put the safety "ON" immediately after you cease firing, and leave it "ON" while transporting or storing the pistol.

Always keep the muzzle pointed in a safe direction until you are ready to fire. Do not allow any part of your body to get in front of the muzzle.



(Fig. 1)

TO OPERATE THE THUMB SAFETY / DECOCKING LEVER

The manual safety is ambidextrous, and consists of two interconnected thumb levers, one on each side of the slide. The safety is "ON" (i.e., in the Safe position) when either lever is pushed upward to cover the red indicator dot on the left side of the slide and expose the white indicator dot. The safety is "OFF" (i.e., in the Fire position) when either lever is pushed down so that the white dot is covered and the red dot is exposed. Always point the muzzle in a safe direction when operating the safety lever.

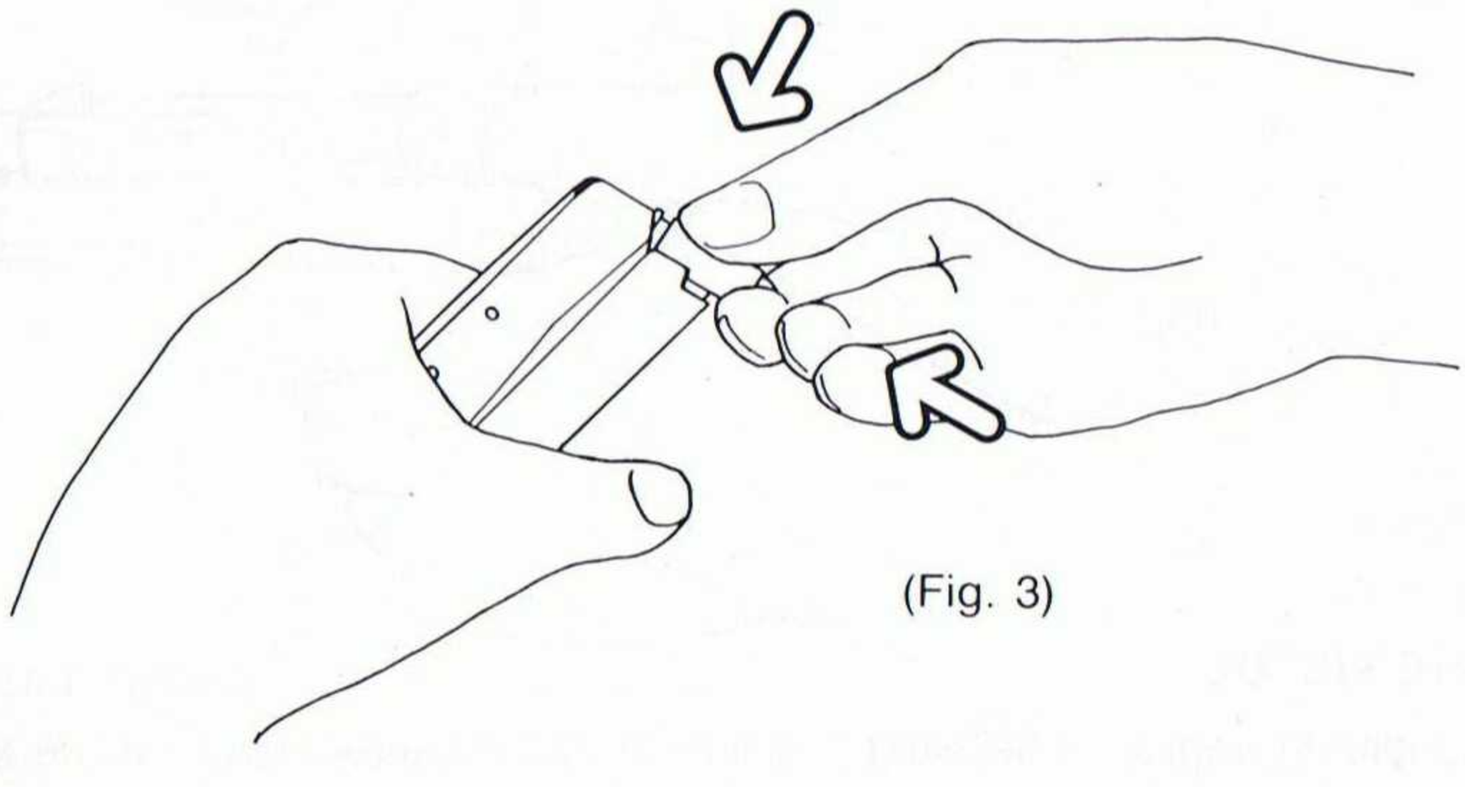
Rotation of either lever to the "ON" position retracts the firing pin (44) into the slide (37) where it cannot be reached by the hammer (31). It also mechanically immobilizes the firing pin (44) in the retracted position.

The manual safety also functions as a selective decocking lever, allowing the shooter to lower the hammer from its full-cock position without pressing the trigger (13) and with the safety "ON". To use the decocking feature, keep the muzzle pointed in a safe direction and push either safety wing "ON". Continue pressing the lever upward further until the hammer (31) snaps down to the uncocked position. The safety is "ON" throughout, preventing the pistol from firing. When the wing is released, it automatically returns to the "ON" position.

(Fig. 2)

TO REMOVE THE MAGAZINE

With the safety "ON" and the muzzle pointed in a safe direction, depress the magazine catch bodis (16) on the frame behind the trigger guard and withdraw the magazine.

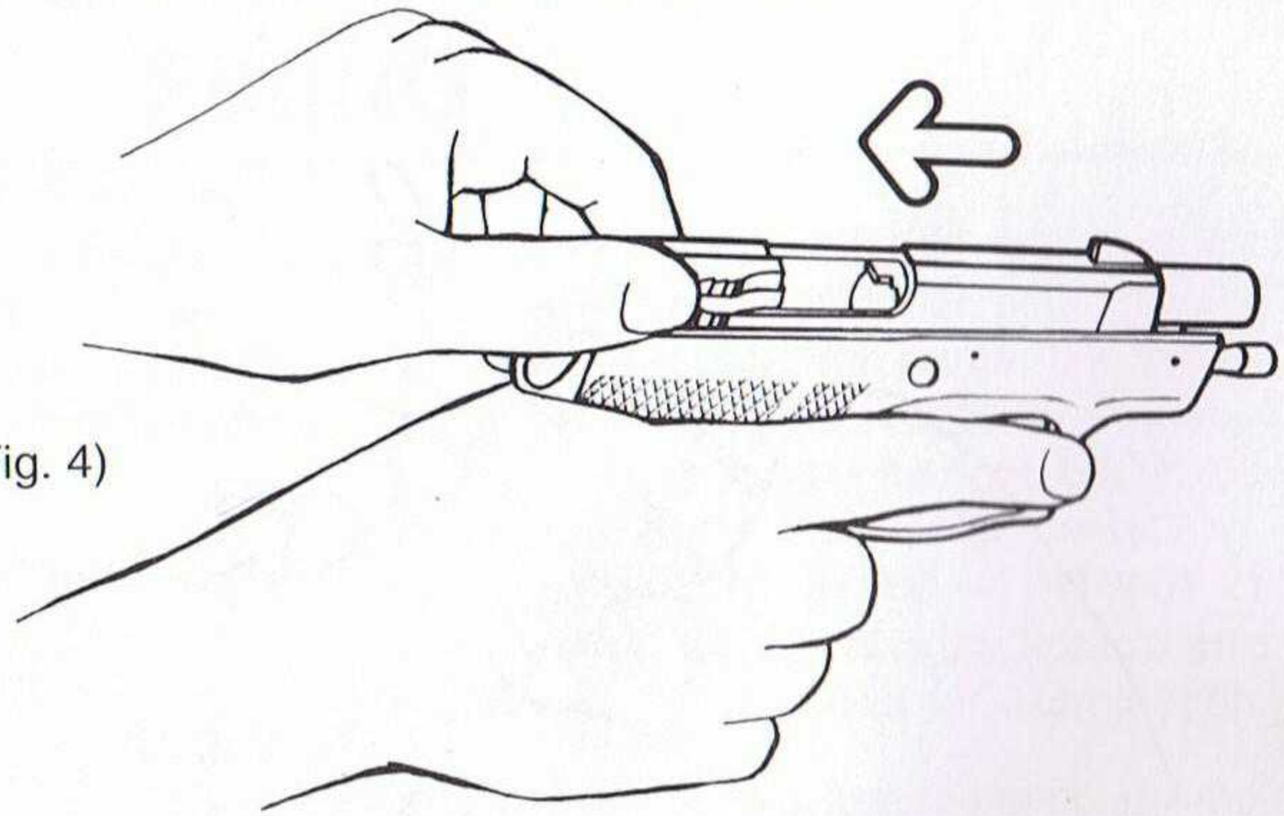


(Fig. 3)

TO LOAD THE MAGAZINE

Load the magazine by inserting each cartridge in two motions: first DOWN to compress the magazine follower spring (62), then REARWARD to slide the cartridge under the magazine lips. The magazine will hold up to 8 cartridges. Holes in both sides side of the magazine allow visual confirmation of the number of cartridges inserted. To empty the magazine, push (do not pull) each cartridge forward until it is no longer held by the magazine lips.

CAUTION: take care not to bend, distort or pry the magazine lips when loading cartridges. Press down the column of cartridges until the top cartridge can be moved smoothly under the lips. DO NOT USE EXCESSIVE FORCE; damaged magazine lips will cause malfunctions.



(Fig. 4)

TO LOAD AND FIRE THE PISTOL

Hold the pistol in a shooting grip with the muzzle pointed in a safe direction or at the target. Put the safety "ON". Insert the magazine into the pistol until it is held by the magazine catch (16). Grasp the serrated surfaces of the slide between thumb and index finger and pull the slide rearwards as far as it will go, then release it smartly. The compressed recoil spring (58) will snap the slide closed, stripping the topmost cartridge from the magazine and loading into the barrel chamber. (Do not "ride" the slide forward with your hand; impeding the slide's movement may cause a feeding jam.)

The pistol is now loaded, hammer cocked and safety "ON". The pistol is ready to fire as soon as the thumb safety is pushed to "OFF" (red indicator dot exposed). If you do not intend to immediately commence firing, decock the hammer. Use either safety wing, not the trigger, for this purpose.

This pistol features two trigger function modes: single-action and double-action. Double-action provides a capability of carrying the loaded pistol safely with the hammer uncocked, yet ready for instant firing simply by pushing the safety "OFF" and pulling the trigger. (If. after de-cocking the shooter desires to fire the first shot single-action, the hammer must first be manually recocked with the thumb.)

A) Single-action mode

The hammer is cocked. Push the safety "OFF". Take aim and lightly squeeze the trigger. The trigger operates in two stages: it first disengages a trigger-actuated firing pin block to permit forward travel of the firing pin. It then releases the hammer, causing it to fall and strike the firing pin. The firing pin (44) is driven forward to indent the cartridge primer and fire the pistol.

B) Double-action mode

The hammer is uncocked. Push the safety "OFF". Take aim and pull the trigger firmly through the full stroke of its travel. In a single motion this will cock the hammer, disengage the firing pin block and then release the hammer to fire the pistol.

After the first shot has been fired from either mode, the hammer will be automatically recocked by the recoil of the slide and all subsequent shots will be fired in single-action mode unless the shooter voluntarily decocks the hammer.

(Fig. 5)

FURTHER HANDLING OF THE PISTOL

When the last shot in the magazine has been fired, the slide will remain open. To resume firing: while keeping the pistol pointed at the target or in a safe direction, insert another loaded magazine and pull down the slide stop lever (29). The slide will snap closed, chambering the first cartridge. The pistol will once again be loaded, hammer cocked, and ready to fire.

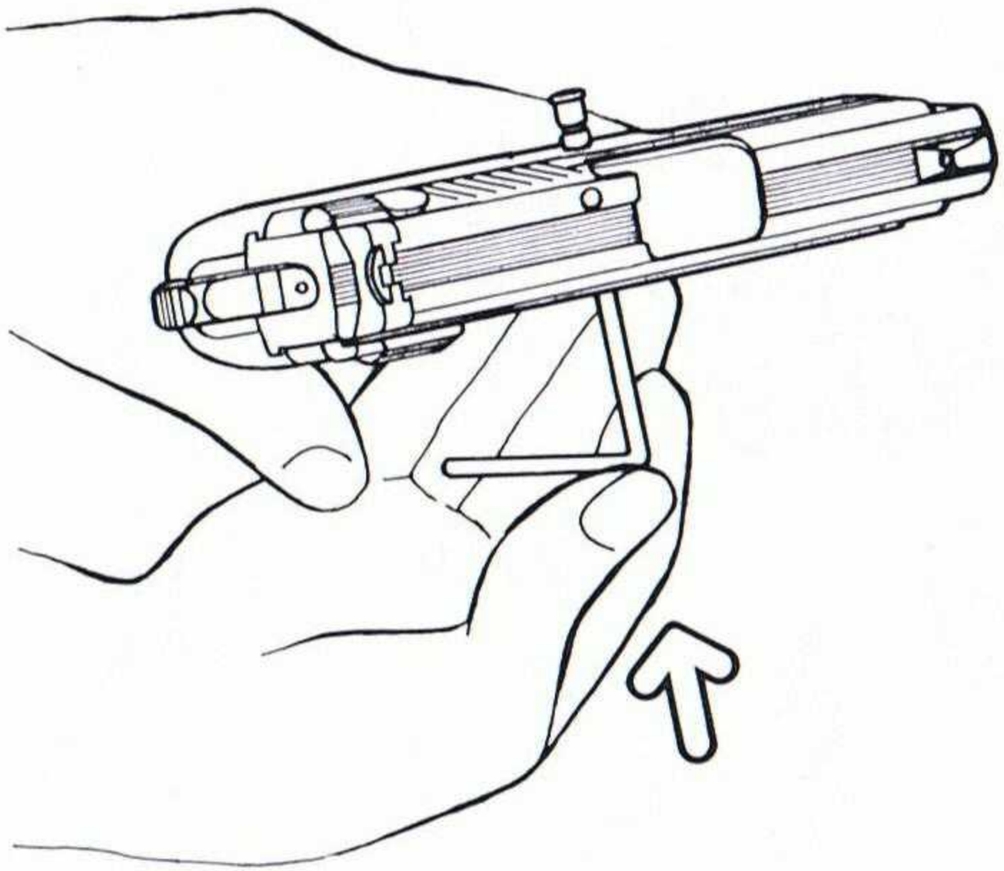
Do not turn away from the target without putting the safety "ON". If firing is discontinued while the pistol is still loaded, keep the muzzle pointed at the target or in a safe direction. Push the safety "ON". First remove the magazine, then pull back the slide smartly to eject the cartridge remaining in the chamber. Visually inspect the chamber to be sure it is empty and unload the magazine.

TO DISASSEMBLE THE PISTOL FOR CLEANING

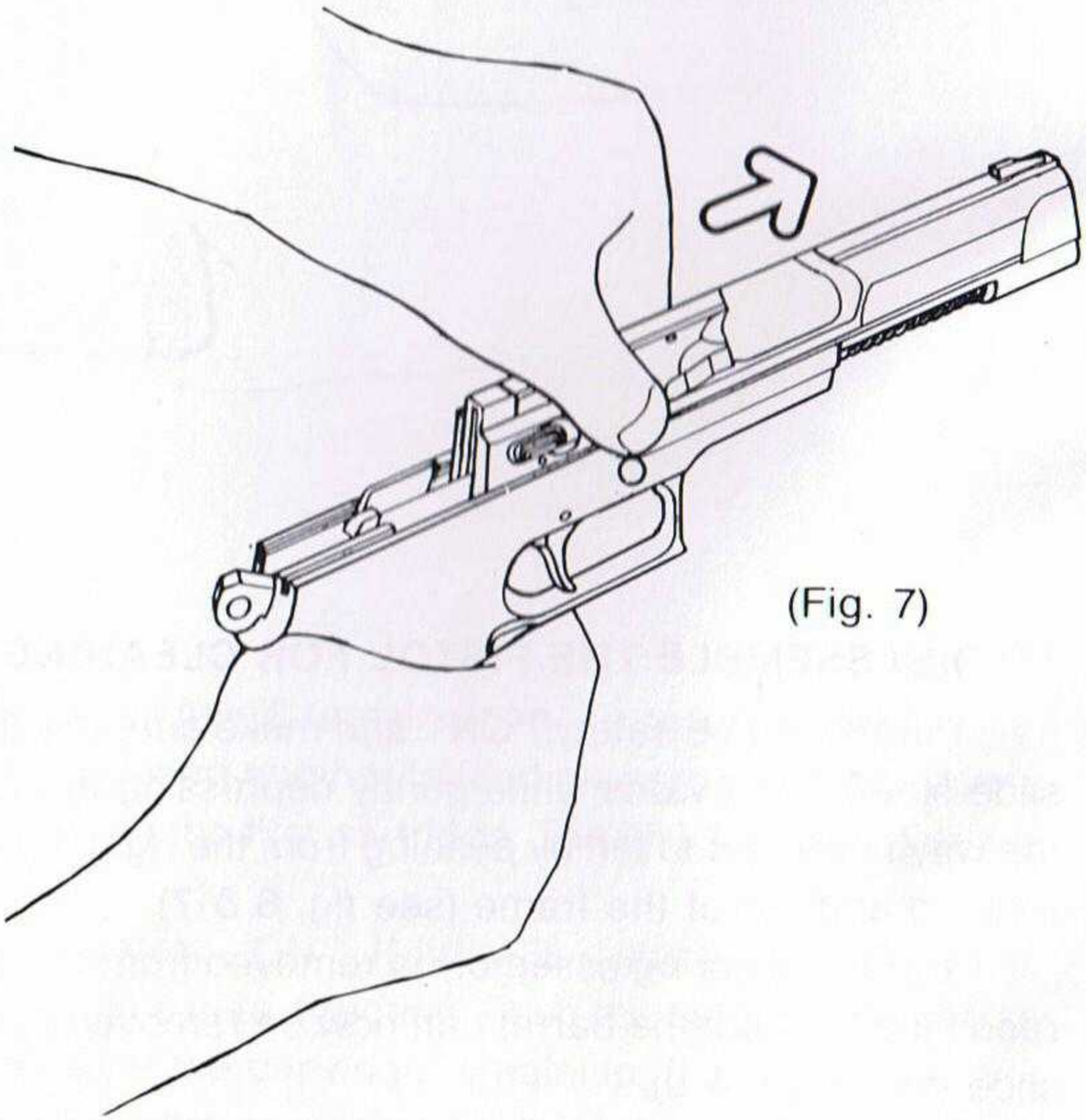
Put the thumb safety "ON" and make sure the firearms is unloaded. Remove the magazine, move the slide slowly backwards while gently depressing the right side of the barrel pin: this will eventually slide all the way from right to left by pushing from the right. The slide-barrel assembly can then be removed by sliding forward and out of the frame (see fig. 6 & 7).

The recoil spring assembly is removed from the slide by slightly compressing the spring and pulling the recoil guide head; the barrel can now be removed by pulling it a little forward and then back and out of the slide (see fig. 8 & 9).

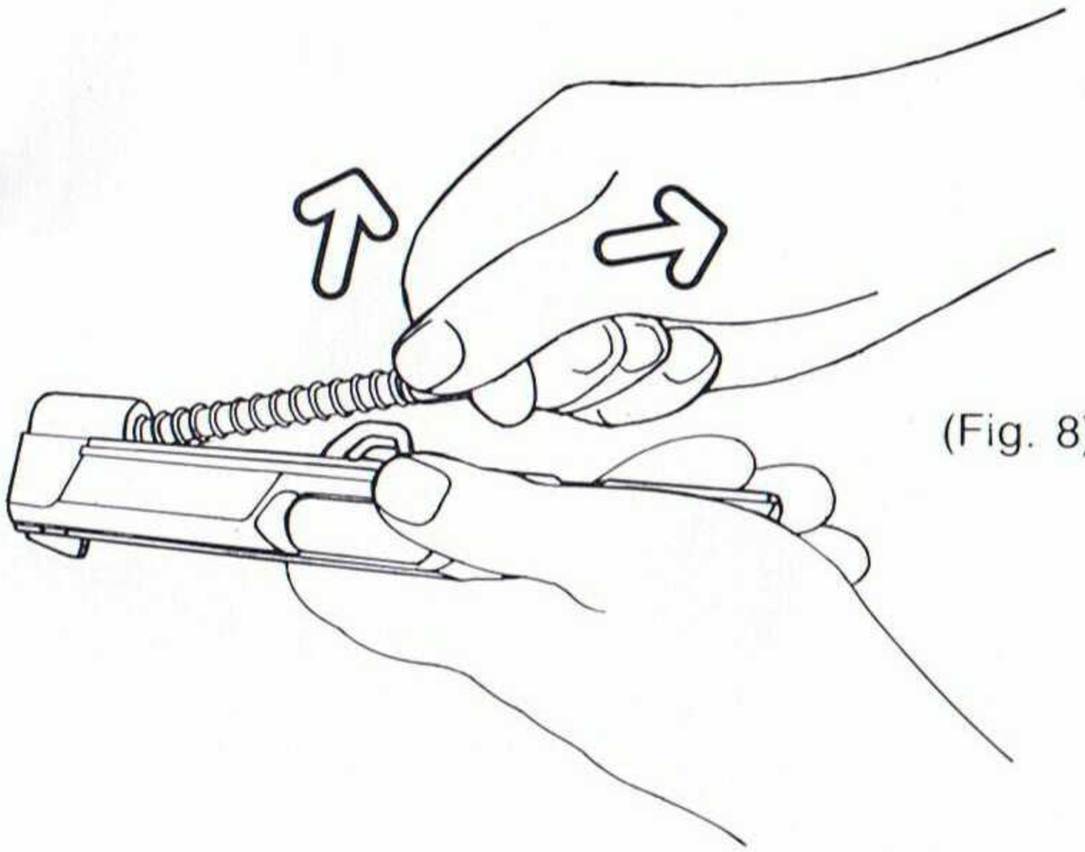
NO FURTHER DISMOUNTING IS NECESSARY TO PROPERLY CLEAN THE PISTOL.



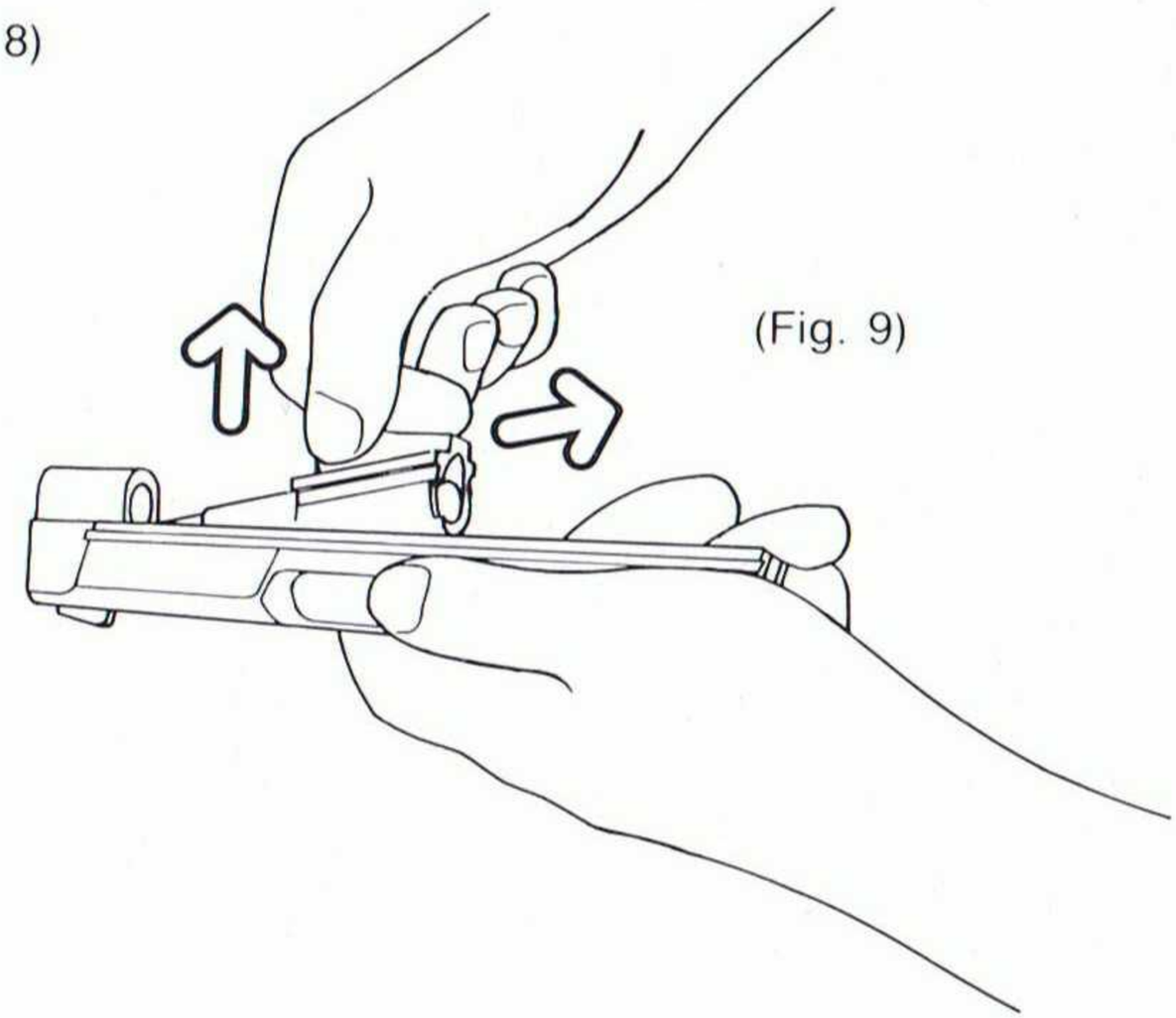
(Fig. 6)



(Fig. 7)



(Fig. 8)



(Fig. 9)

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